Amendments To The Claims:

1-9. (Cancelled)

10. (Currently Amended) A method of forming a polymeric tubing segment for a medical device comprising extruding a tube of polymer material through a die and cooling the extruded tubing by drawing it through a cooling region spaced at a gap length from the die to the cooling bath, wherein at least the gap length ~~length, or the cooling rate of the cooling region, or any a combination thereof~~, is altered at least once along the length of the segment, whereby the segment is formed with at least two regions along the length thereof, a first of said regions and a second of said regions having different longitudinal extruded orientations relative to each other.

11. (Original) A method as in claim 10 further comprising the step of cutting the tubing segment from the extruded tube in a manner such that said regions occur at predetermined locations along the length of the tubing.

12. (Currently Amended) A method as in claim 10 wherein a plurality of said tubing segments are formed in the extruded and drawn tube, said gap length or ~~cooling rate or~~ a combination of gap length and cooling rate of the cooling region ~~thereof,~~ being varied between at least two different value sets along the length of each said tubing segment.

13. (Cancelled)

14. (Currently Amended) A method comprising extruding a tube of polymer material through a die and cooling the extruded tubing by drawing it through a cooling region spaced at a gap length from the die to the cooling bath, wherein ~~the drawing rate, or~~ at least the gap length ~~length, or the cooling rate of the cooling region, or any combination thereof,~~ is altered at least once along the length of the segment, whereby the segment is formed with at least two regions along the length thereof, a first of said regions and a second of said regions having different longitudinal extruded orientations relative to each

other, and forming a catheter shaft from said segment, the catheter shaft having proximal and distal regions, the shaft having a higher longitudinal orientation in the proximal region relative to the orientation of the shaft in the distal region.

15. (Previously Presented) A method as in claim 10 further comprising providing the tubing segment as a parison for a catheter balloon and forming a catheter balloon from said parison.

16. (Currently Amended) A method as in claim 15 wherein the gap length, or <u>a combination of the gap length and</u> the cooling rate of the cooling region, ~~or combination thereof,~~ is altered at least a second time along the length of the segment whereby the segment is formed with at least a third region along the length thereof, the third region having a different longitudinal extruded orientation relative to at least the second region.

17. (Currently Amended) A method as in claim 16 wherein the gap length, or <u>the combination of the gap length and</u> the cooling rate of the cooling region, ~~or combination thereof,~~ is altered to provide the first, second and third regions in sequential order with the second region having a higher or lower longitudinal orientation relative to both the first and third regions.

18. (Original) A method as in claim 10 wherein the tubing material is a single polymer.

19. (Original) A method as in claim 10 wherein the tubing is coextruded as a laminate of at least two different polymers.

20. (Original) A method as in claim 10 wherein the tubing material comprises a polymer blend.

21. (Original) A method as in claim 10 wherein the wall thickness of the tubing segment is varied over the length thereof.

22. (Original) A method as in claim 21 wherein the wall thickness is varied concurrently with the variation in longitudinal orientation in said at least two regions.

23. (Currently Amended) A method of making a parison for forming a medical device balloon in which portions of the parison are slated to form cone and waist portions of the balloon and a portion is slated to form the balloon body, the method comprising a step of extruding polymeric material to form ~~the~~ a tube, and forming the parison having said slated portions from the tube, wherein the extruding step is controlled to provide the extruded tube with a varying longitudinal orientation, such that the slated parison formed therefrom has variation providing a lower or higher orientation for the cone and waist slated portions of the parison relative to the portion slated to form the balloon body.

24. (Original) A method as in claim 23 wherein the extruding step is controlled to provide the portion slated to form the body with a higher relative longitudinal orientation, the portions slated to form the waists of the balloon with a lower relative longitudinal orientation and the portions slated to form the cones of the balloon with a varying longitudinal orientation ranging between the higher and the lower relative orientations.

25. (Original) A method as in claim 23 wherein the extruding step is controlled to provide the extruded tube with a varying wall thickness, the variation providing a lower wall thickness for the cone and waist slated portions of the parison relative to the portion slated to form the balloon body.

26. (Currently Amended) A method of forming a polymeric tubing segment for a medical device comprising extruding a tube of polymeric material through a die and cooling the extruded tubing by drawing it through a cooling region spaced at a gap length from the die to the cooling bath, wherein <u>at least</u> the gap <u>length</u> ~~length, or the cooling rate of the cooling region, or any combination thereof,~~ is altered along the length of the segment, whereby the segment is formed with at least two regions along the length

thereof, a first of said regions and a second of said regions having different elongation at yield properties relative to each other.

27. (Currently Amended) A method as in claim 26 wherein the gap length, or a combination of gap length and the cooling rate of the cooling region, ~~or combination thereof,~~ is altered to provide one of said regions with a elongation at yield which is at least 20% below the elongation at yield of another of said regions.

28. (Amended) A method as in claim 26 wherein the gap length, or the combination of the gap length and the cooling rate of the cooling region, ~~or combination thereof,~~ is altered to provide one of said regions with a elongation at yield which is 30% below the elongation at yield of another of said regions.

29. (Cancelled)

30. (Original) A method as in claim 26 wherein the wall thickness of the tubing segment is varied over the length thereof.

31. (Original) A method as in claim 30 wherein the tube is extruded through a die gap and the wall thickness is varied by varying the die gap.

32. (Previously Presented) A method as in claim 31 wherein the wall thickness of the tubing segment is varied concurrently with the variation in elongation at yield in said at least two regions.

33. (Original) A method as in claim 26 wherein the polymeric material comprises a polyamide/polyether/polyester, a polyester/polyether block copolymer, a polyurethane block copolymer or a mixture thereof.

34. (Original) A method as in claim 26 wherein the polymeric material is a

polyamide/polyether/polyester.

35. (Original) A method as in claim 26 wherein the extruded tube is formed with a single layer of polymeric material.

36. (Original) A method as in claim 26 wherein the extruded tube is formed with a plurality of layers of polymeric material.

37. (Original) A method as in claim 26 wherein the polymeric material comprises at least two different polymers.

38 - 42 (Cancelled)

43. (Previously Presented) A method of forming a polymeric tubing segment for a medical device comprising extruding a tube of polymeric material through a die and cooling the extruded tubing by drawing it through a cooling region spaced at a gap length from the die to the cooling bath, wherein the drawing rate, or the gap length, or the cooling rate of the cooling region, or any combination thereof, is altered along the length of the segment, whereby the segment is formed with at least two regions along the length thereof, a first of said regions and a second of said regions having different elongation at yield properties relative to each other and wherein

said alteration of the drawing rate, or the gap length, or the cooling rate of the cooling region, or combination thereof, is selected on the basis of the elongation at yield properties of said first and second regions.

44. (Previously Presented) A method as in claim 43 wherein said alteration is selected to provide one of said regions with a elongation at yield which is at least 20% below the elongation at yield of another of said regions.

45. (Previously Presented) A method as in claim 43 wherein said alteration is selected

to provide one of said regions with a elongation at yield which is 30% below the elongation at yield of another of said regions.